

1.016.735



RESERVE COPY. PATENT SPECIFICATION

DRAWINGS ATTACHED

1.016.735

Inventor: ERIC CRISP LEWIS

Date of filing Complete Specification: July 10, 1963.

Application Date: May 31, 1963.

No. 21787/63.

Complete Specification Published: Jan. 12, 1966.

© Crown Copyright 1966.

Index at acceptance:—B3 A(26, 83); B8 D(1A1, 1B1, 1B2, 7M)

Int. Cl.:—B 23 p // B 65 d

COMPLETE SPECIFICATION

Improvements in and in the manufacture of Metal Casks

I, ERIC CRISP LEWIS, a British subject of 41 Bishops Close, Ham Common, Surrey, and ALUMASC LIMITED, a British Company of 49 Moorgate, London E.C.2, do hereby declare the invention for which I pray that a patent may be granted to us, and the method by which it is to be performed, to be particularly described in and by the following statement:—

The object of this invention is to provide an improved method of manufacture of metal casks especially for containing beer or other edible liquids whereby not only is such manufacture facilitated but also an improved construction of cask is obtained particularly as regards the ease with which the cask can be cleaned and maintained in a hygienic condition.

According to this invention the method of manufacture of metal casks is characterised by constructing the body of the cask by metal pressing and securing, such as by welding, cast rims or chimes to the ends of the cask body.

In the accompanying drawings:—

FIGURES 1 and 2 are elevational views both in axial plane section of casks constructed in accordance with the invention

Like parts are designated by the same or similar reference numerals in the drawings.

Referring to the drawings the cask body 1 is constructed from two identical, or substantially identical complementary pressings, 2, 2 which are shown welded together at and about the largest diameter or bilge 3 of the body 1.

By means of a suitable power press employing appropriate dies each pressing or body half 2 is pressed out from flat sheet or plate metal which may be of aluminium or stainless steel. Owing to the nature of such a pressing operation an extremely smooth inner surface can be imparted to each pressing 2 and maintenance of the cask interior in a clean and hygienic condition. The pressing operation may also include the formation of a rib 4 about each pressing 2 adjacent the bilge 3.

In order to mainly complete the cask and also in accordance with the invention the body 1 is provided with a rim or chime 5 at each end, each chime 5 being produced as a casting (e.g. in aluminium or aluminium alloy) and welded at 6 to the end of a corresponding pressing 2 of the body 1.

By employing chimes 5 of cast form they may be readily produced to the required shape including recessing 7 for lifting and handling purposes whilst in particular the form of the cast chime can be such as to provide adequate support at the corner 8 of the corresponding pressing 2.

Thus as shown the base 5a of each chime 5 is such that the corner 8 of a corresponding pressing 2 has a seating fit with said base 5a. As a result it will be noted that the corners 8 of the pressings 2 are able to be of quite large curvature which further facilitates cleaning of the cask and in particular enables internal recesses to be obviated which would otherwise harbour undesired matter.

Thus internal formations difficult to clean or wash and which occur where the chime is included in the body pressing are avoided whilst the above mentioned practical advantages of the welded on cast chimes 5 would not be obtained, or readily obtained, by employing pressed or extruded chimes.

It will therefore be appreciated that the method of cask manufacture and resulting cask construction according to this invention combines the advantages of pressed metal and cast metal techniques in an effective manner in providing a satisfactory form of cask to meet the particular requirements of brewers and other users whilst quantity production of such casks can be readily and economically carried out. Moreover the casks are of light weight yet of adequate strength.

Further in accordance with this invention other permanent fittings of the cask may be of cast form welded to the pressed metal body 1. Thus in FIGURE 1 there is shown a cast boss or ring 9 welded about a

bung hole or similar opening 10 at the bilge 3, the boss 9 including a continuation 4a of the ribbing 4. Also in FIGURE 1 a further cast boss or ring 11 is shown integral with the associated chime 5 and in register with an end inlet or outlet opening 12 in the corresponding pressing 2.

Referring to FIGURE 2 the end wall of the pressing 2 shown uppermost is provided with a cast ring 13 welded in a central opening 14 which ring 13 removably receives a fluidtight closure 15 (also of cast construction) and shown carrying valve means 16 and a depending draw-off tube 17.

The inner surfaces of the cask body 1 should be treated against corrosion and in this connection the pressings 2,2, may be formed from commercial aluminium sheet which is clad with substantially pure aluminium in order that the corrosion resistant properties of the latter may be provided at the inner surfaces of the cask.

WHAT WE CLAIM IS:—

1. Method of manufacture of metal casks characterised by constructing the body of the cask by metal pressing and securing, such as by welding, cast rims or chimes to the ends of the cask body.

2. Method of manufacture of metal casks

according to claim 1 wherein each chime is formed so as to have a seating fit with the corner of a corresponding cask body end.

3. Method of manufacture of metal casks according to claim 1 or 2 wherein the cask body is formed by two complementary pressings welded together at and about the largest diameter or bilge of the cask.

4. Method of manufacture of metal casks according to claim 1, 2 or 3 wherein one or more cast bosses or rings are welded about a corresponding opening or openings in the pressed metal body.

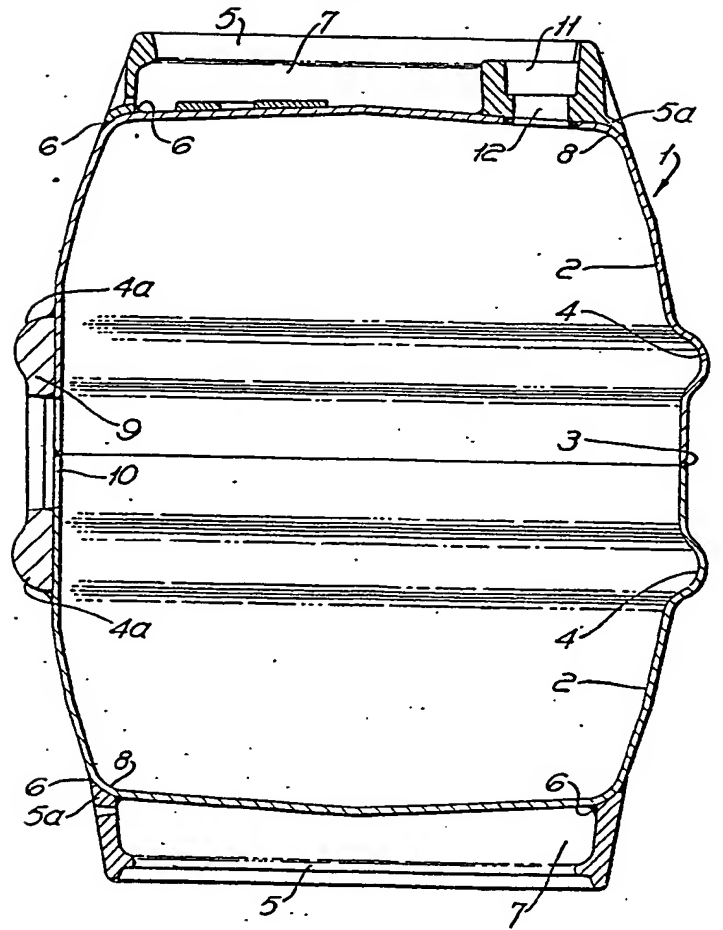
5. Method of manufacture of metal casks according to claim 4 wherein at least one cast boss or ring for an end opening of the cask is formed integrally with an associated cast end rim or chime.

6. Metal casks when produced by the method of manufacture according to any of the preceding claims.

7. Method of manufacture of metal casks and metal casks when produced thereby substantially as herein described with reference to the accompanying drawings.

T. FLETCHER WILSON.
Chartered Patent Agent.
3 Queens Road, Coventry.
Agent for the Applicants.

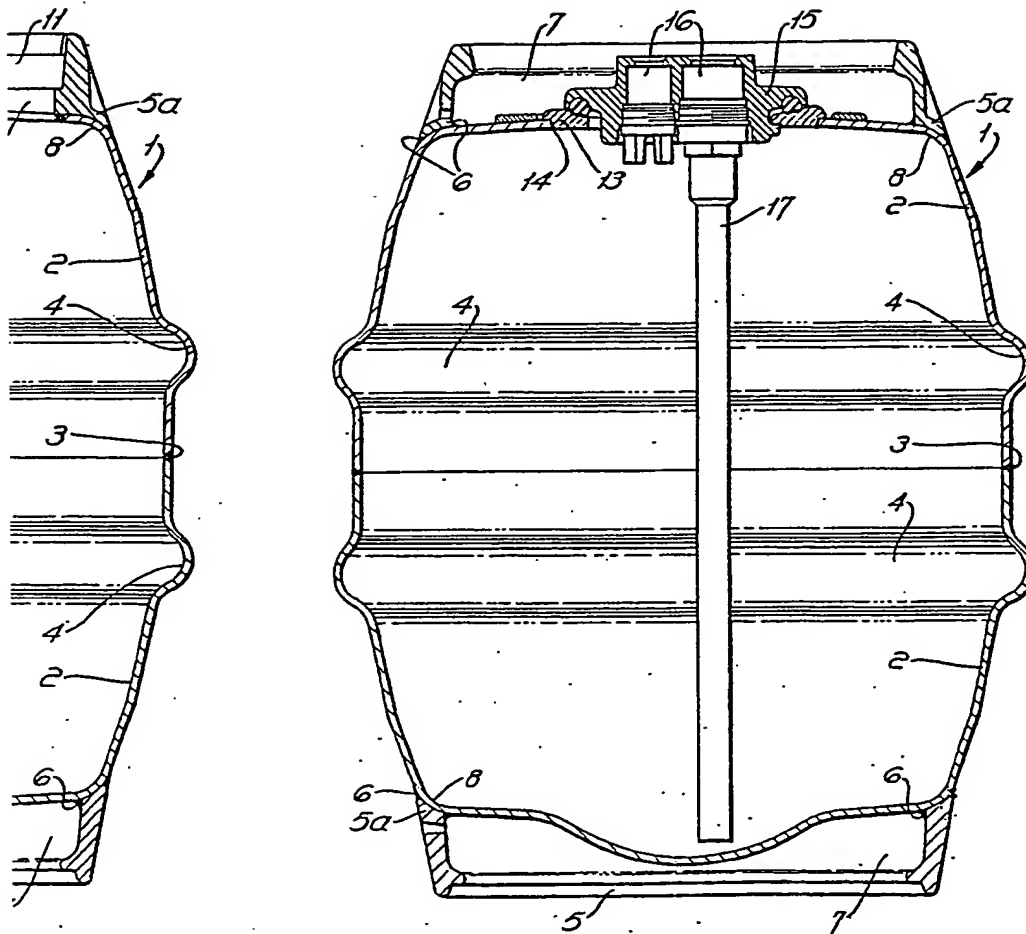
FIG. 1.



1016735 COMPLETE SPECIFICATION

2 SHEETS This drawing is a reproduction of
the Original on a reduced scale
Sheets 1 & 2

FIG. 2



1016735 COMPLETE SPECIFICATION
 2 SHEETS
 This drawing is a reproduction of
 the Original on a reduced scale
 Sheets 1 & 2

